

Work Order ID 121825

July-07-14 12:46:01 PM

LAP
121825

Page 1

Item ID: D2151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Packer Doubler

Start Date: 7/14/14 Start Qty: 80.00

80

Cust Item ID:

Required Date: 7/14/14 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2151

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2151

Dwg Rev: *B*

2024.040

Prog Rev: *B*

2-Deburr if necessary

85

mm

14/07/14

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

85

mm

14/07/14

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Item ID: D2151 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Packer Doubler
 Start Date: 7/14/14 Start Qty: 80.00 ***80*** Cust Item ID:
 Required Date: 7/14/14 Req'd Qty: 80.00 ***80*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 27 9-89 0.00 147/14				89 Clen			
130 *130* Small Fab Small Fab Small Fab	Small Fab Memo Debur	0.00 0.00				85			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				85			7/14/14

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Item ID: D2151 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Packer Doubler
Start Date: 7/14/14 Start Qty: 80.00 ***80*** Cust Item ID:
Required Date: 7/14/14 Req'd Qty: 80.00 ***80*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>M 10 89 89</i> Memo START TIME: <i>8:40.</i> OVEN TEMPERATURE: <i>300°</i> <i>9/10</i>	0.00 0.00				<i>85</i>	<i>14-7-22</i>	<i>85</i>	<i>9-89</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>88</i>	<i>14/07/22</i>	DAS 27 9-89	<i>85</i> <i>cont</i>			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>STU 3</i>	0.00 0.00				<i>14/7/22</i>	<i>85</i>	<i>85</i>	

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Item ID: D2151

Accept

N900040100Setup Start ***NS1***

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Stop ***NS2***

Start Date: 7/14/14 Start Qty: 80.00

80

Cust Item ID:

Required Date: 7/14/14 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

14/7/23 *[Signature]*
[Signature] 4.7.22

Picklist Print

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Page 1

Work Order ID: 121825

121825

Parent Item: D2151

D2151

Parent Item Name: Packer Doubler

Start Date: 7/14/14

Required Date: 7/14/14

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP C00.10.23Re-format (mpp 2101)EC

IPP Rev:D 06-04-28 Manufactured on Water Jet JLM

IPP Rev:E 06-11-24 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			110	sf	225.0440	0.035	3			

M2024T3S 040

2024-T3 .040 sheet

mm 17/07/11

Location

Loc Qty

Loc Code

MAT022

225.044

m127582

63.374

m128354

29.97

m129236

131.7

3.6

DART AEROSPACE LTD		Work Order: 121825
Description: Packer		Part Number: D2151
Inspection Dwg: D2151 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.099	✓		V-Scm-01	
Ø0.171	+0.005/-0.000	0.172	✓			
0.231	+/-0.010	0.231	✓			
1.217	+/-0.010	1.217	✓			
2.194	+/-0.010	2.193	✓			
2.300	+/-0.010	2.300	✓			
1.560	+/-0.010	1.560	✓			
0.250	+/-0.010	0.250	✓			
1.328	+/-0.010	1.328	✓			
0.342	+/-0.010	0.342	✓			
0.740	+/-0.010	0.740	✓			
2.050	+/-0.010	2.050	✓			
0.040	+/-0.010	0.039	✓			

Measured by: mm Date: 14/07/14	DAS 27 9-89 Audited by: [Signature] Date: 14/7/14	Prototype Approval: N/A Date: N/A
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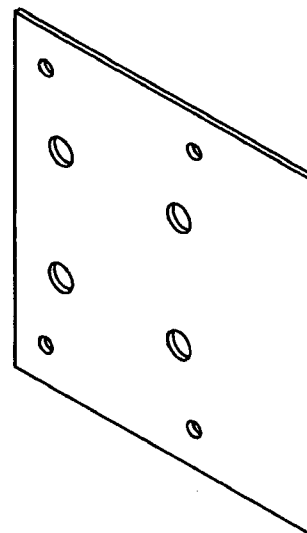
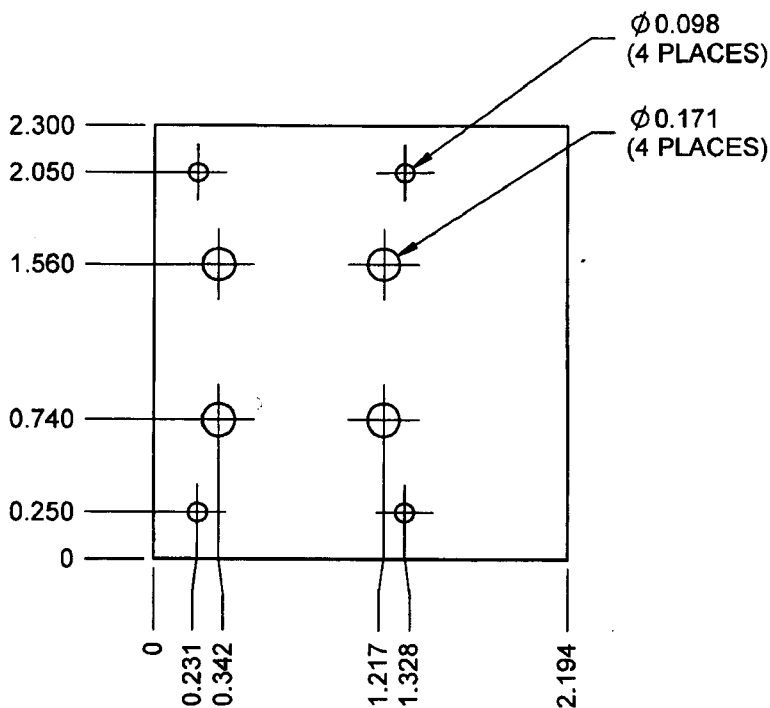
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM [Signature]	[Signature]



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2151	REV. B SHEET 1 OF 1
DATE 06.10.13		TITLE PACKER	SCALE 1:1
REV	DATE	DESCRIPTION	
A	95.05.01	NEW ISSUE	
B	06.10.13	UPDATE DRAWING	

RELEASED

06.11.20 **[Signature]**



D2151 PACKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121825 MCS
140704

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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